



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-300
Job Sheet 169555



Part No: SWA6A-300

Job Qty: 10 ea

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA6A-300 Rev3 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/28/17	12/28/17	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	12/28/17	12/28/17	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	12/29/17	12/29/17	0.00	10.00	MORI NLX		
120	QC	10 pcs	12/29/17	12/29/17	0.00	0.00	QC2		
130	QC	10 pcs	12/29/17	12/29/17	0.00	0.00	QC8		
140	Packaging	10 pcs	12/29/17	12/29/17	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea	12/29/17	12/29/17	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 3.375"

Descriptions: 110 - 1-Machine as per DWG. FB706 FOLIO REV: _____ DWG REV: _____ 2-Debur

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R3.500	3	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/3/18 11:59 AM Dart.lajeunesse.marie

2086'



S040760



Bearing Housing

SWA6A - 300

PART NO:

Original Serial #: S040760

Revision:

Operation:

Change No:

Start up Operation 02/09/18
Job No: 169555

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE LTD		Work Order: 169555
Description: Bearing Housing		Part Number:
Inspection Dwg: SWA6A-300	Rev: 3	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.04x45°	+/- .01 x .5°	.04x45°	✓		Vern LPO8	
1.431	+ .003 / - .000	1.433				
.120	+/- .005	.121				
.645	+/- .005	.648				
.02x45°	+/- .01 x .5°	.02x45°				
.142	+/- .005	.143				
.959	+/- .005	.962				
.105	+ .000 / - .005	.103				
.02x45°	+/- .01 x .5°	.02x45°				
.03x45°	+/- .01 x .5°	.03x45°				
1.969	+ .002 / - .000	1.970				
Ø 2.124 / 2.1247		2.1241				
Ø 2.559	+ .003 / - .000	2.560				
Ø 2.640	+ .005	2.640				
Ø 3.063	+ .005	3.064				
3-16 UN-2B	GO/NOGO	GO				
.103	+ .005 / - .000	.106				
Ø 3.005	+ .005	3.005				
Ø 3.182	+/- .006	3.183				
Ø 3.425	+ .005	3.423				
3.223	+ .005	3.226				
.709	+/- .005	.709				
Ø 2.32	+/- .01	2.320				
.04x45°	+/- .01 x .5°	.04x45°				
R.25	+/- .01	.250				

Measured by: P	Checked by: FK	QC Inspector:
Date: 18-02-08	Date: 18-2-10	Date:

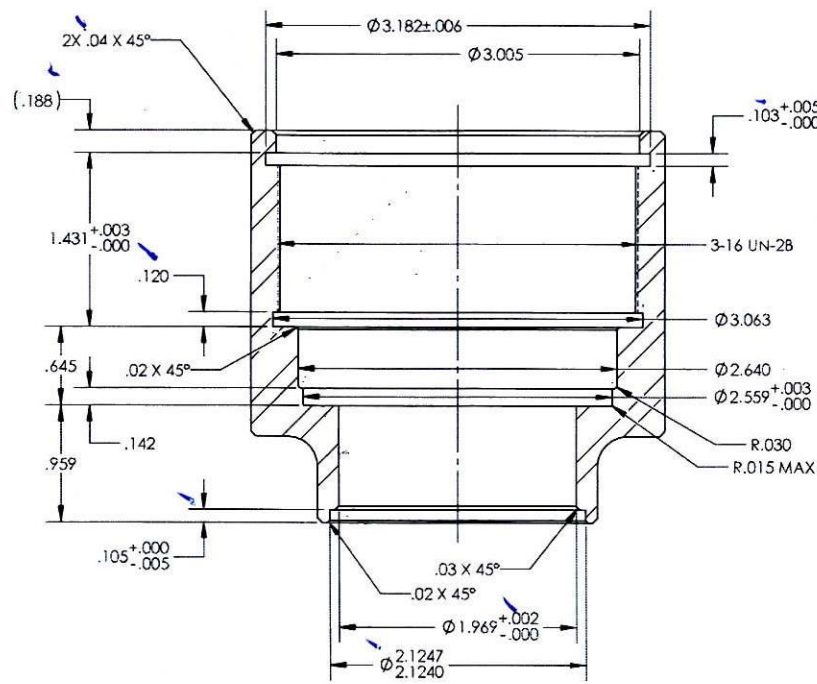
Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

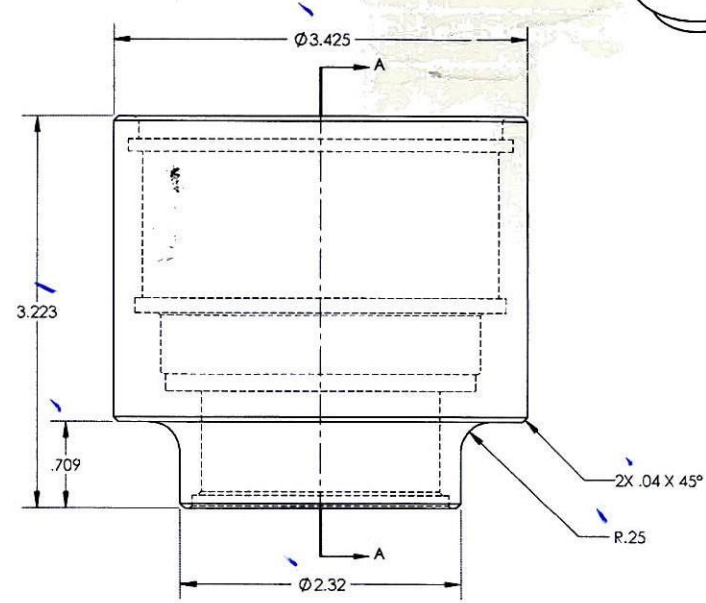
7-4-H1150-R3.500
5037874

This drawing, specifications, and concepts contained herein are the sole property of Dart Aerospace and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		AS DRAWN BY CANAM		11/19/2012	JAG	
2		CHD TOLERANCE FROM Ø2.125+0.001/-0.001 ADDED H1150 SPEC TO MATERIAL CALLOUT.		11/19/2012	JAG	
3	15-0305	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATERIAL OPTION 1075, CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.		10/16/2015	DPD	JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169511 MJS
1712-13

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	

DART AEROSPACE	
TITLE: BEARING HOUSING	
DWG NO. SWA6A-300	REV 3
MAT'L: SS 17-4 H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES	APPROVED: <i>D. Wood</i>
XXX ± .005 FRACTIONS ± 1/8	TEST:
.XX ± .01 ANGLES ±.5°	TREAT:
.X ± .1	FINISH:
1. BREAK ALL SHARP EDGES .015 ± .45°	SPEC:
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL:
SCALE: 1:1	DATE: 2/1/2002
SHEET 1 OF 1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																													
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																														
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																														
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																														
Large Fab ☐	Composite ☐	Supplier ☐																																																																																															
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																																													
Description Work Order Deviation		Disposition		Completed By																																																																																													
				Lead hand / Supervisor Approval Verification																																																																																													
				QC / QA Coordinator Approval																																																																																													
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4"></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td colspan="4"></td> </tr> </table>		Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐					Misidentified ☐	Past Due ☐					FAULT CATEGORY <table style="width:100%;"> <tr> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐	Fit/Function ☐	Misread ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																																												
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																																												
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																																												
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																																												
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																																												
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																																												
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																																												
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																																												
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																																												
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																																												
Past Expiry Date ☐	Manufacturing Process ☐																																																																																																
Misidentified ☐	Past Due ☐																																																																																																
Power Loss/Surge ☐	Positioned Wrong ☐																																																																																																
Folio/Program ☐	Outside Dimensions ☐																																																																																																
Grain ☐	Over/Under tolerance ☐																																																																																																
Weld ☐	Part Incorrect ☐																																																																																																
Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																																																
Out of Sequence ☐	Part Moved ☐																																																																																																
Off-set ☐	Drawing ☐																																																																																																
Mislabeled ☐	Finish ☐																																																																																																
Fit/Function ☐	Misread ☐																																																																																																
Misaligned/off center ☐	Turning Sequence ☐																																																																																																
OTHER : _____																																																																																																	